

Order 11943



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D350-591-133
Job Sheet 188879



Part No: D350-591-133

Job Qty: 2 pcs

Part Name: AFT Maintenance Step, Fits LH or RH



Part Weight: 0 lbs

Priority: Medium

Job Created: 1/16/19

Status: New

Due Date: 2/12/19

Job Tracking No:
Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG DS19712 REV A , IIN-D350-591 REV H , D2946 REV.C IPP Rev.B 05.10.14 Modified step 10 KJ/EC IPP Rev.C

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Workcenter/Supplier		Sign-off
						Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	2 pcs	2/12/19	2/12/19	0.00 1.39	Large Fab - 1		
						Large Fab - 10		SLC
						Large Fab - 2		
						Large Fab - 3		
						Large Fab - 4		
						Large Fab - 5		
						Large Fab - 6		
						Large Fab - 7		
						Large Fab - 8		
						Large Fab - 9		
120	QC 6	2 pcs	2/12/19	2/12/19	0.00 0.00	QC 6 - 38		DAS
						QC 6 - 42		38
						QC 6 - 9		9-86
						QC 6 - 68		
						QC 6 - 61		
130	Large Fab - Welded Assy-2-B4B	2 pcs	2/12/19	2/12/19	0.00 1.39	Large Fab - 1 - B4B		
						Large Fab - 10 - B4B		SLC
						Large Fab - 2 - B4B		
						Large Fab - 3 - B4B		
						Large Fab - 4 - B4B		
						Large Fab - 5 - B4B		
						Large Fab - 6 - B4B		
						Large Fab - 7 - B4B		
						Large Fab - 8 - B4B		
						Large Fab - 9 - B4B		
140	QC 9	2 pcs	2/12/19	2/12/19	0.00 0.00	QC 9 - 10		
						QC 9 - 18		
						QC 9 - 24		QC
						QC 9 - 43		

150 QC 5	2 pcs	2/12/19	0.00 0.00	QC 9 - 50	
				QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	CPC
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
160 Handfinish - 1-1 Chemical- B4B	2 pcs	2/12/19	0.00 0.30	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/01/22
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 QC 7	2 pcs	2/12/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	

					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 38	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	DAS JAN 22 2019 68
					QC 7 - 50	9-89
					QC 7 - 67	
180	Large Fab - Welded Assy-3-B4B	2 pcs	2/12/19	0.00 1.39	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	SL4
190	QC 10	2 pcs	2/12/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	DAS
					QC 10 - 38	38
					QC 10 - 43	9-89
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
200	QC 5	2 pcs	2/12/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS
					QC 5 - 38	38
					QC 5 - 42	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
210	Handfinish - 1-2- Chemical-B4B	2 pcs	2/12/19	0.00 0.30	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	D.R 19/01/29

					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
220	Powdercoat - 1 White GI(A)- B4B	2 pcs	2/12/19	0.00 0.21	Powdercoat - 1 - B4B	BEB 19-01-29.
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
230	Handfinish - 3-1- WingWalk- B4B	2 pcs	2/12/19	0.00 0.00	Handfinish - 3 - 1 - B4B	BEB 19-01-29.
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
240	QC 3	2 pcs	2/12/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	DAS
					QC 3 - 36	38
					QC 3 - 38	9-89
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	

250	Packaging 1-1 - Pick Kit - B4B	2 pcs	2/12/19	0.00 0.00	QC 3 - 9	
					Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	JAN 30 2019
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
260	QC 4	2 pcs	2/12/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	DAS
					QC 4 - 69	69
					QC 4 - 9	9-89
					QC 4 - 46	DAS
270	Packaging 3-1 - Stock - B4B	2 pcs	2/12/19	0.00 0.00	Packaging 3 - 1 - B4B	69
					Packaging 3 - 2 - B4B	9-89
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	2	2/12/19	0.00 0.00	DC - 1 - B4B	DAG
	pcs			DC - 2 - B4B	21 JAN 31 2019
280 QC 21 - FG	2	2/12/19	0.00 0.00	QC 21 - FG - 21	21 JAN 31 2019
	pcs			QC 21 - FG - 70	21 JAN 31 2019

Part Op 110 - (Fabricate per Drwg) 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946 2- Drill vent hole as per dwg
 Descriptions: using DT10462 and c'sink.

- 120 - (QC6- All purchased or subcontracted products)
- 130 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Deburr and Bevel ends for welding Use DT8440 jig
- 140 - (QC9- Inspect visual per QSI004- Fusion Welds)
- 150 - (QC5- Inspect part completeness to step on W/O)
- 160 - (Chemical Conversion Coat per QSI005 4.1)
- 170 - (QC7-Inspect Chemical Conversion Coat)
- 180 - (Weld per dwg A/R Aluminum rod Batch: _____) 1- Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. 2- Install rivet in vent hole as per dwg
- 190 - (QC10- Inspect visual per QSI004- ground welds)
- 200 - (QC5- Inspect part completeness to step on W/O)
- 210 - (Chemical Conversion Coat per QSI005 4.1)
- 220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 2:00 TEMP: 320" FINISH: 2:30
- 230 - (Wing Walk as per dwg QSI005 4.4 Batch M138963.
- 240 - (QC3- Inspect Part Finish)
- 250 - (Pick Kit)
- 260 - (QC4- 100% Inspect kits for completeness)
- 270 - Identify and pack for shipping as per PPPD350-591-133 Location:FG038
- 275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-133 CHG004
- 280 - QC21- Final Inspection - Work Order Release)

M138997

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (1 ea)	110-Large Fab - Steps - 1	\$104007
D2734	Step End Plate	4 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	\$102822
D2944	Step Mounting Plate	4 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	\$06650
MS20601-AD4W2	Rivet	2 Ea (1 ea)	180-Large Fab - Welded Assy-3- B4B	\$083539
AN4-11A	Bolt	8 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$130325
AN4-16A	Bolt	16 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$147270
AN4-7A	Bolt	4 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$057520
D2230-1	Mounting Lug	8 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$129816
D2230-3	Mounting Lug	8 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$137811
D2732-030	Rubber Cushion - 3"	8 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$141533
D2945	Mounting Plate	2 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$078919
D3338-1	Mounting Lug	2 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$104230
MS21042L4	Nut	28 Ea (14 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$133333
NAS1149D0463J	Washer	28 Ea (14 ea)	250-Packaging 1-1 - Pick Kit - B4B	\$130345

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	2	295	0
130-Large Fab - Welded Assy-2- B4B	D2734	4	45	0
	D2944	4	26	0
180-Large Fab - Welded Assy-3- B4B	MS20601-AD4W2	2	52	0
250-Packaging 1-1 - Pick Kit - B4B	AN4-11A	8	120	0
	AN4-16A	16	327	0
	AN4-7A	4	166	0
	D2230-1	8	178	0
	D2230-3	8	114	0
	D2732-030	8	420	0
	D2945	2	28	0
	D3338-1	2	68	0
	MS21042L4	28	1,968	0
	NAS1149D0463J	28	2,732	0

Part Specifications

Specifications could not be found.

* Macdonald.Dara

7585

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Container No: S146073



Part: D350-591-133

Job No: 188879

Serial No/Batch: S146073

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1d4cFAA21STC SH967NE 0